



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C3-13-4-2

Job Sheet 185874



Part No: C3-13-4-2

Job Qty: 2 ea

Part Name: Keeperless Adapter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/6/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C3-13-4-2 REV.4 IPP REV A 18.07.24 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Machining-3		AT 18-11-20
110	Mori Seiki	2 pcs	11/23/18	11/23/18	0.00	1.00	MORI NV5000-1		AT 18-11-20
120	QC	2 pcs	11/23/18	11/23/18	0.00	0.00	QC2 Machining-4		AT 18-11-21
130	QC	2 pcs	11/23/18	11/23/18	0.00	0.00	QC8 Machining-4		AT 18-11-22
135	Outsource	2 pcs	11/23/18	11/23/18			ATL002-VC Metcor		CC 18-11-26
148	Outsource	2 pcs	11/23/18	11/23/18			GRO002-VC 5		CC 18-12-11
150	Packaging	2 pcs	11/23/18	11/23/18	0.00	0.00	Packaging2		DEC 1 1 2018
160	QC	2 pcs	11/23/18	11/23/18	0.00	0.00	QC6		DEC 1 1 2018
210	Packaging	2 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-1		DEC 1 9 2018
220	QC21-SA	2 Ea	11/23/18	11/23/18	0.00	0.00	QC21		DEC 1 9 2018

Part Op 110 - 1-Machine as per folio FC 495 FOLIO REV: _____ DWG REV: _____ 2-Deburr
Descriptions: 135 - 1-Issue P/O to METCORE; P/O 041850 RC 40-44 2-Bead blast 3--Material type steel; 4- Certificate of
Conformity is required ***NOTE*** DROP SHIP TO FINISHER METCORE to ship directly to GROUPE ALTECH ***
148 - 1-Issue P/O to Groupe Altech: P/O 042006 -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-
.0006 -Bake after plating -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-1.500X2.000	4140 Steel Bar 1.500 X 2.000	.6420 (.321 ea)	90-Start up Operation	5124011 6ea

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-B-1.500X2.000	1	0	0



Container No: S129082



Part: C3-13-4-2

Job No: 185874

Serial No/Batch: S129082

Revision: 4

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ifications

ould not be found.

Plex 11/6/18 10:09 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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				QC / QA Coordinator Approval																																																																
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DART AEROSPACE LTD		Work Order:	15587K
Description: keeperless adapter		Part Number:	C3-13-4-2
Inspection Dwg:	Rev: 4	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.258	H/- .005	.259	✓		ML 06	
.771	H/- .005	.770	✓		ML 06	
.600	H/- .005	.600	✓		ML 06	
1.911	H/- .005	1.913	✓		height gage	
2x .13 ▽	H/- .010	.130	✓		ML 06	
.206	H/- .005	.207	✓		ML 06	
.875	H/- .005	.876	✓		pin	
1.286	H/- .005	1.287	✓		ML 06	
.04x45°	H/- .010	.040	✓		ML 06	
2x R.01/.03	H/- .010	.010	✓		visual	
.343	H/- .005	.346	✓		ML 06	
Ø.375	- .001 to .006	.374	✓		pin	
1.8x .800	H/- .010	1.378	✓		pin	
▽.04	H/- .010	.040	✓		ML 06	
.596	H/- .005	.5915	✓		ML 06	
1.86	H/- .010	1.851	✓		height gage	
2.78	H/- .010	2.772	✓		ML 06	
3.62	H/- .010	3.611	✓		ML 06	
.313	H/- .005	.312	✓		pin	
.568	H/- .005	.566	✓		ML 06	
.693	H/- .005	.688	✓		ML 06	

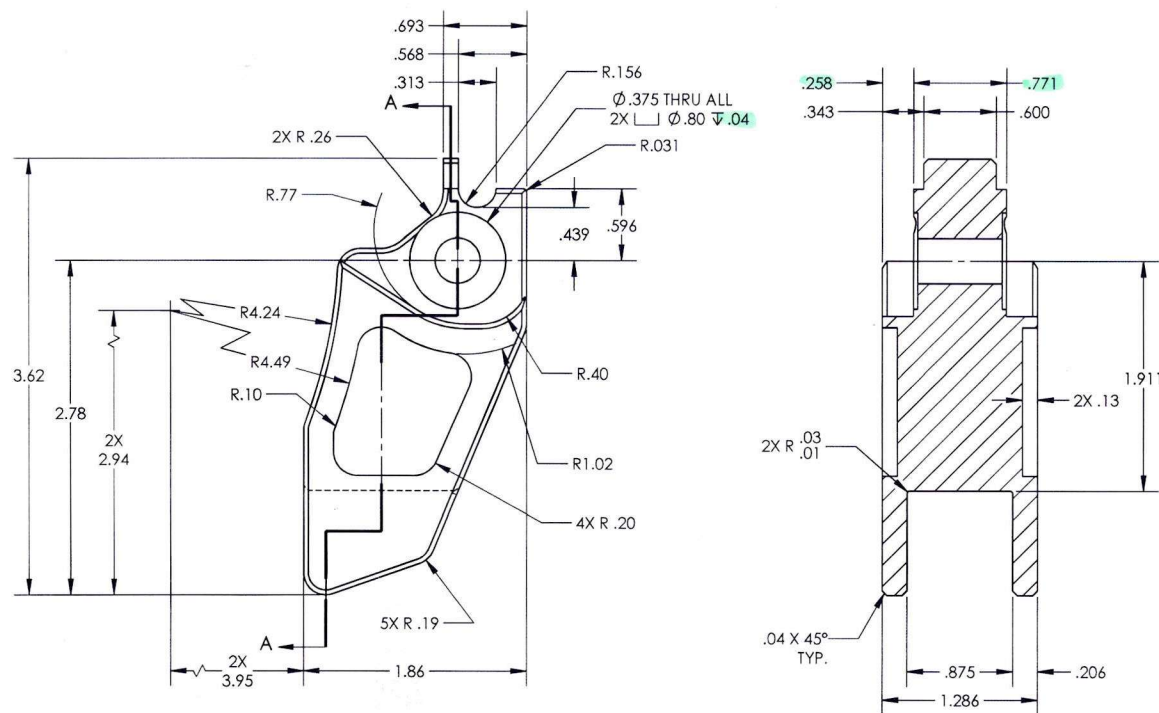
Measured by: P.S. / mlf	Checked by: B.R.	QC Inspector:	
Date: 20 Nov 2018	Date: 18-11-22	Date:	

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2		AS DRAWN BY CANAM.	6/21/2002	DPD
3	15-0195	CH'D RADIUS WAS R.03 IS R.03 - .01, ADDED NOTE 3, ADDED HEAT TREAT HRC 40-44.	8/5/2015	RJC
4	17-0140	UPDATED TO NEW DRAFTING STANDARD. CH'D DIMS WAS .784 IS .771, WAS 2X .258, WAS 2X .343 IS .343.	6/16/2017	RJC



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185874 MLC
18-11-06

- NOTES:
1. NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.
 2. USE DXF PROFILE FOR PART CONTOURS.
 3. MACHINE ENGRAVE BATCH NUMBER.

DART AEROSPACE															
TITLE KEEPERLESS ADAPTOR C3-HOOK															
DWG NO. C3-13-4-2	REV 4														
<table border="1"> <tr> <td>MAT'L 4140/4142</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>FEAT HRC 40-44</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>TREAT SEE NOTE 1</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>FINISH SEE NOTE 1</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td>SPEC</td> <td>.X ± .1 SURFACES ± 125/</td> </tr> </table>		MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED	FEAT HRC 40-44	DIMENSIONS ARE IN INCHES	TREAT SEE NOTE 1	.XXX ± .005 FRACTIONS ± 1/8	FINISH SEE NOTE 1	.XX ± .01 ANGLES ± 5°	SPEC	.X ± .1 SURFACES ± 125/				
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	USED ON MODEL														
SCALE 1:1	DATE 6/16/2017														
SHEET 1 OF 1															

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C3-13-4-2	1	KEEPERLESS ADAPTOR C3-HOOK	4140/4142	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041850**

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO041850
PO Date: 11/26/18
Due Date: 12/18/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments: ** Please advise of fastest ETA **

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185874	C3-13-4-2	Keeperless Adapter 1-Issue P/O to METCORE; P/O RC 40-44 2-Bead blast 3-Material type steel; 4- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER METCORE to ship directly to GROUPE ALTECH *** Material 4140	Firmed	-	12/18/18	5 pcs	0 pcs	5 pcs	\$60.00/pcs	\$300.00
2	185774	646.3314	Blade HEAT TREAT AS PER DWG 646.3300 FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL	Firmed	-	12/18/18	30 pcs	0 pcs	30 pcs	\$8.666666670/pcs	\$260.00
Grand Total:											\$560.00



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041850

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/29/18 3:30 PM dart.tsimiklis.chrisoula

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
332352	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

GROUP ALTECH

2455 ALPERN

ST LAURENT

1

QC H4S1N9

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
41850	N/A	4140		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SEL HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed		RÉSULTATS DE TESTS / results	
HARDNESS	40 - 44 HRC		5 (907)	43 - 44 HRC
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
5	5.5	C3-13-4-2 (5) C3-13-4-2 JOB 185874 1 SAC DE PLASTIQUE		

COMMENTAIRES / comments

SALT HARDEN 1550F, 40 MIN

TEMPER 850F, 2 HRS

TEMPER 875F, 2 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification.

All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée.

Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous vous signalons qu'il est strictement interdit de les divulguer, de les reproduire ou d'en utiliser de quelque manière que ce soit le contenu. Toute exportation ou réexportation non autorisée est interdite.

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
332352	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

GROUP ALTECH

2455 ALPERN

ST LAURENT

QC H4S1N9

1

APPROUVÉ par / Approved by:

Isabel Otero

Isabel Otero

QA Technician



DATE: 2018-12-10



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042006**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042006
PO Date: 12/11/18
Due Date: 12/17/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments: *advise with fastest lead time please *

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185874	C3-13-4-2	Keeperless Adapter -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Certificate of Conformity is required	Firmed	-	12/17/18	5 pcs	0 pcs	5 pcs	\$5.5144927/pcs	\$27.57
2	185266	C45-3-4	Pin -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 - Certificate of Conformity is required	Firmed	-	12/17/18	64 pcs	0 pcs	64 pcs	\$5.5144927/pcs	\$352.93
Grand Total:											\$380.50

revised

CR



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042006

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

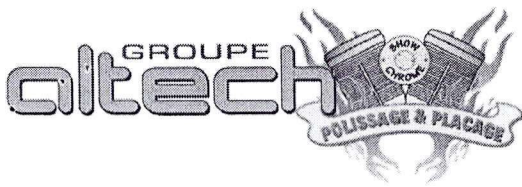
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/17/18 8:12 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(015248-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

015248 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
14-Dec-2018		Aman		042006				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	C3-13-4-2 Rev.	C3-13-4-2 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] QQ-N-290 CLASS 2 GRADE E 0.0004-0.0006 THICK BAKE AFTER PLATING	E-NICKEL STEEL CH	5	5	0	0	0
2	C45-3-4 Rev.	C45-3-4 01 -E-NIC STEEL 500 [E-NICKEL STEEL 500] QQ-N-290 , CLASS 2, GRADE E TO F: .0004 - .0006 ***	E-NICKEL-500 CH	64	64	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.